

~~Aug 24/10~~
Work Order ID 63085-2

October 20, 2010 3:09:51 PM



Page 1

Item ID: D3891-041

Revision ID:

Item Name: Panel, Fwd LH

Start Date: 10/20/10 Start Qty: 2.00

Required Date: 10/21/10 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 10-10-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3891

A

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg D3891-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B10-10-20

2

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B10-10-20

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Page 2

Item ID: D3891-041

Revision ID:

Item Name: Panel, Fwd LH

Start Date: 10/20/10 Start Qty: 2.00

Required Date: 10/21/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/10/25

(+2)

2

10/21



QC

Memo

Quality Control

130

Small Fab

0.00

8/10/10/25 (2)

(2X)

Small Fab

Memo

Small Fab

Deburr if necessary

= 7 m. d w/10/21

140

Pick Kit

0.00

= 7 m. d w/10/25

(2X)



Packaging

Memo

Packaging

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Small Fab

Memo

1- Bond gasket to smooth side of panel as per dwg

A/R 3M 1300 adhesive Batch: ~~113174~~

0.00

0.00

160



QC

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 251A

Memo

0.00

0.00

14
ppp
63112

(2X)













(2X)

(X2)

Comp/26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3891-041 PAR #: N/A Fault Category: Small fab NCR: (Yes) No DQA: 1/1 Date: 10.11.08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1/1 Date: 10/11/08

NCR: <u>63085 (2)</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/21	150	1 part of D3891-3 after glue made air bubble RPROCESS		Scrap & destroy D3891-3 cut 1 D3891-3 B6328 m.k By hand per dwg D3891-3 Everything!! Replace Qty 1 foam made	10/10/22			
				foam replace by hand per dwg D3891-3 D3891-3 B M112335	m.k 10/10/25			
				D3891-1 m.k 5.175 - P600294-04 m# 115261 x2	SC-01-01 10/10/25			

NOTE: Date & initial all entries

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Item ID: D3891-041

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Start Date: 10/20/10 Start Qty: 2.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/26
MK

10-10-26

Print

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Page 1

Work Order ID: 63085



Parent Item: D3891-041



Parent Item Name: Panel, Fwd LH

Start Date: 10/20/10

Required Date: 10/21/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,253.803	4.656	9.802105			



1810-10-20

Location

Loc Qty

Loc Code

MAT

1253.8038

1253.8038

115261

D3891-3



Gasket

Manufactured No

140 Each 0.0000



115261

2

~~B 63090~~

~~810101~~ 810

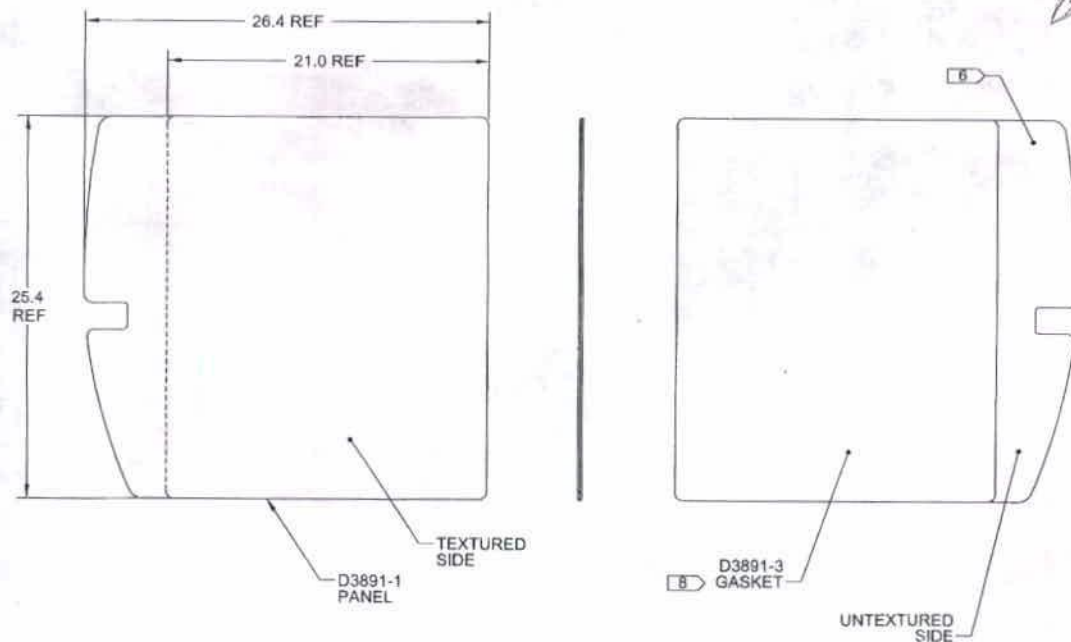
SEE NCR FOR
REPLACEMENT

48

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63085
B/W-20



D3891-041 PANEL, FWD LH

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

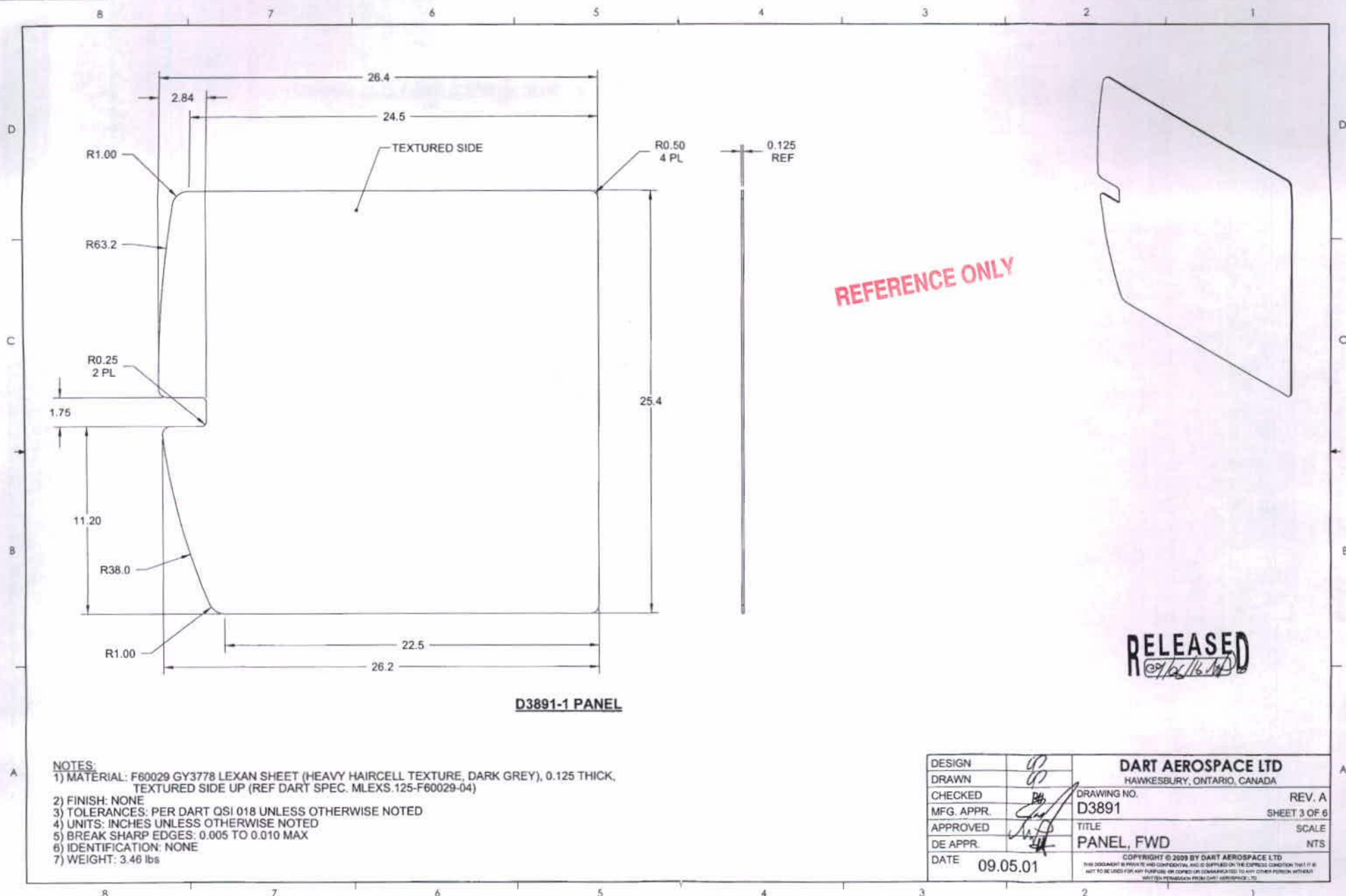
RELEASED
C9/06/16

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>JP</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	09.05.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3891
REV. A
SHEET 1 OF 6
TITLE PANEL, FWD
SCALE NTS

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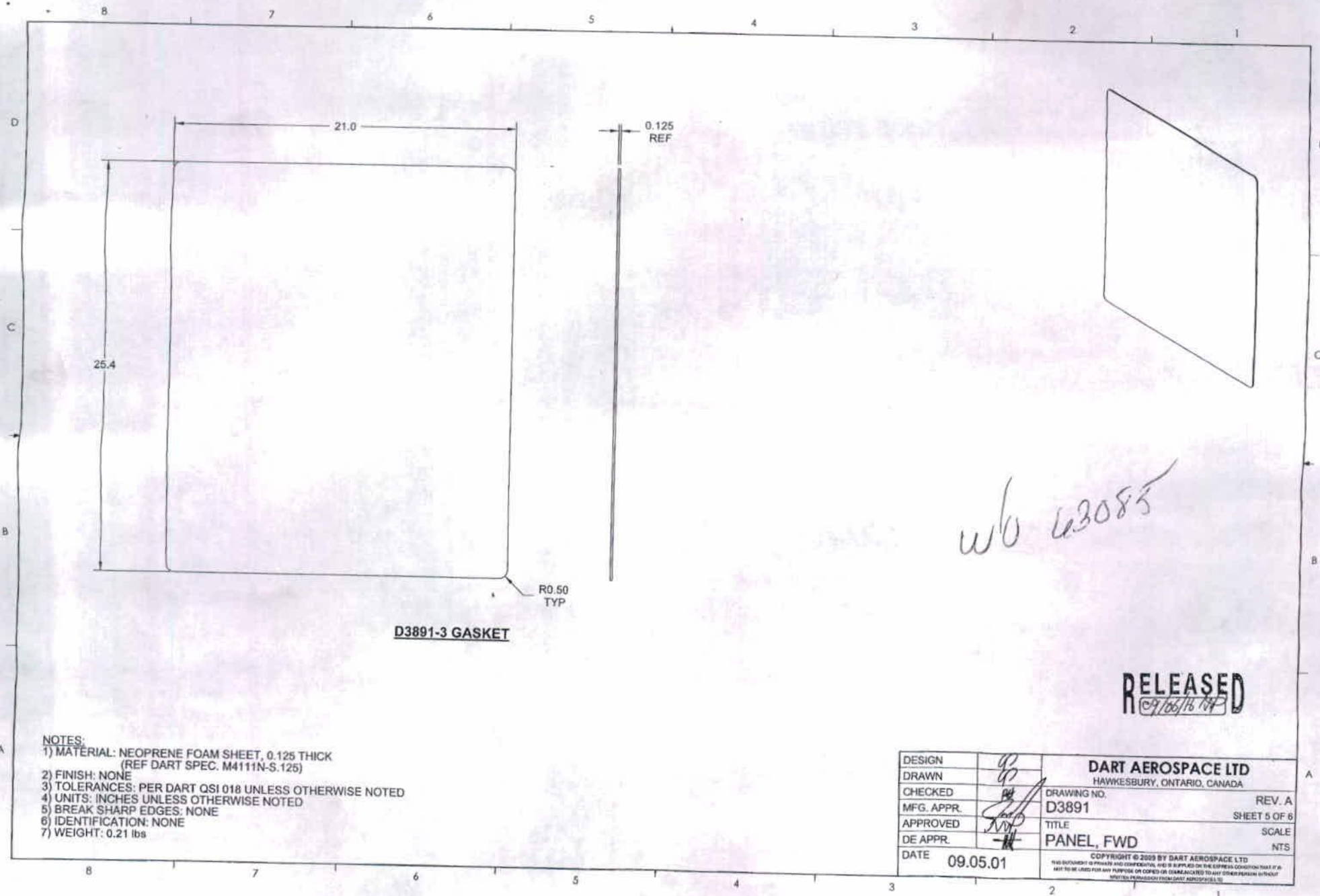
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09/05/01

D3891-1 PANEL

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3891	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FWD	NTS
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D3891-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

wb 63085

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09/05/16

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MFG. APPR.	<i>[Signature]</i>	TITLE PANEL, FWD	SHEET 5 OF 6
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